



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3302-02-1

Job Sheet 171380



Part No: RBE350A93-3302-02-1

Job Qty: 6 ea

Part Name: Handle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3302-02-1 REV:11 IPP REV A 18.01.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/8/18	0.00	0.00	Start Up Machining-4		18/02/21
120	CNC Vertical Machining	6 pcs		2/9/18	1.50	1.00	MORI NV5000-1		18/02/22
130	QC	6 pcs		2/9/18	0.00	0.00	QC2 Machining-5		18/02/23
140	QC	6 pcs		2/9/18	0.00	0.00	QC8 Machining-5		18-02-27
170	Outsource	6 pcs		2/9/18	0.00	0.00	Outsource4		AT 18/03/14
180	Packaging	6 pcs		2/9/18	0.00	0.00	Packaging2		ADAT 18/03/14
190	QC	6 pcs		2/9/18	0.00	0.00	QC6		38
200	Packaging	6 pcs		2/9/18	0.00	0.00	Packaging3-2		MAR 16 2018
210	QC21-SA	6 Ea		2/9/18	0.00	0.00	QC21		21 MAR 2 12 2018

Part Op 120 - 1-Machine as per folio FB 810 FOLIO REV: DWG REV: 2-Debur

Descriptions: 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to ATG: 039182 ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

200 - Identify and Stock

MAR 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	6 ft (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	6	34	0

Part Specifications

Specifications could not be found.

Plex 1/31/18 1:44 PM Dart.lajeunesse.marie

5044905
4
7

AML 3-21

FM138109-5

129639-1
5006782-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order DART AEROSPACE Container No: S044908 Part No: RBE350A93 - 3302 - 02 - 1 NCR # Job No: 171380 Date: Serial No/Batch: S044908 Revision: _____ Inspector: _____ Date: 02/23/18	DISPOSITION Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																
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Large Fab ☐	Composite ☐	Supplier ☐																	
		QTY Effective :	MRB (QSI042) Approval																
		Disposition																	
			Completed By																
			Lead hand / Supervisor Approval Verification																
			QC / QA Coordinator Approval																
FAULT CATEGORY																			
El _____ E _____ Inte _____ Trib _____	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence																
LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Product Improv. ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Marks/Chatter ☐ OTHER : _____																	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

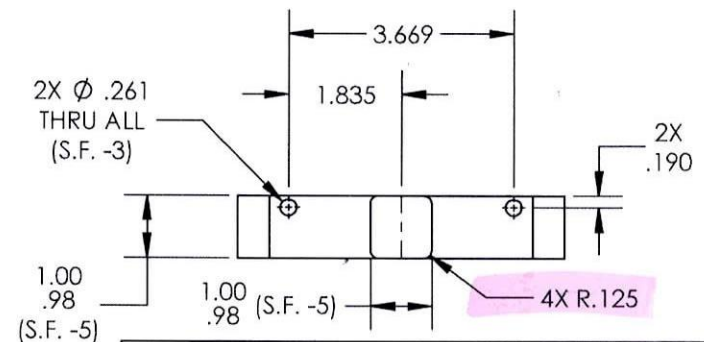
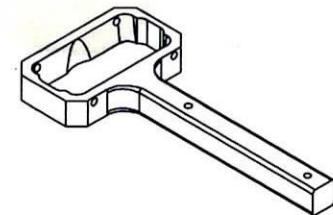
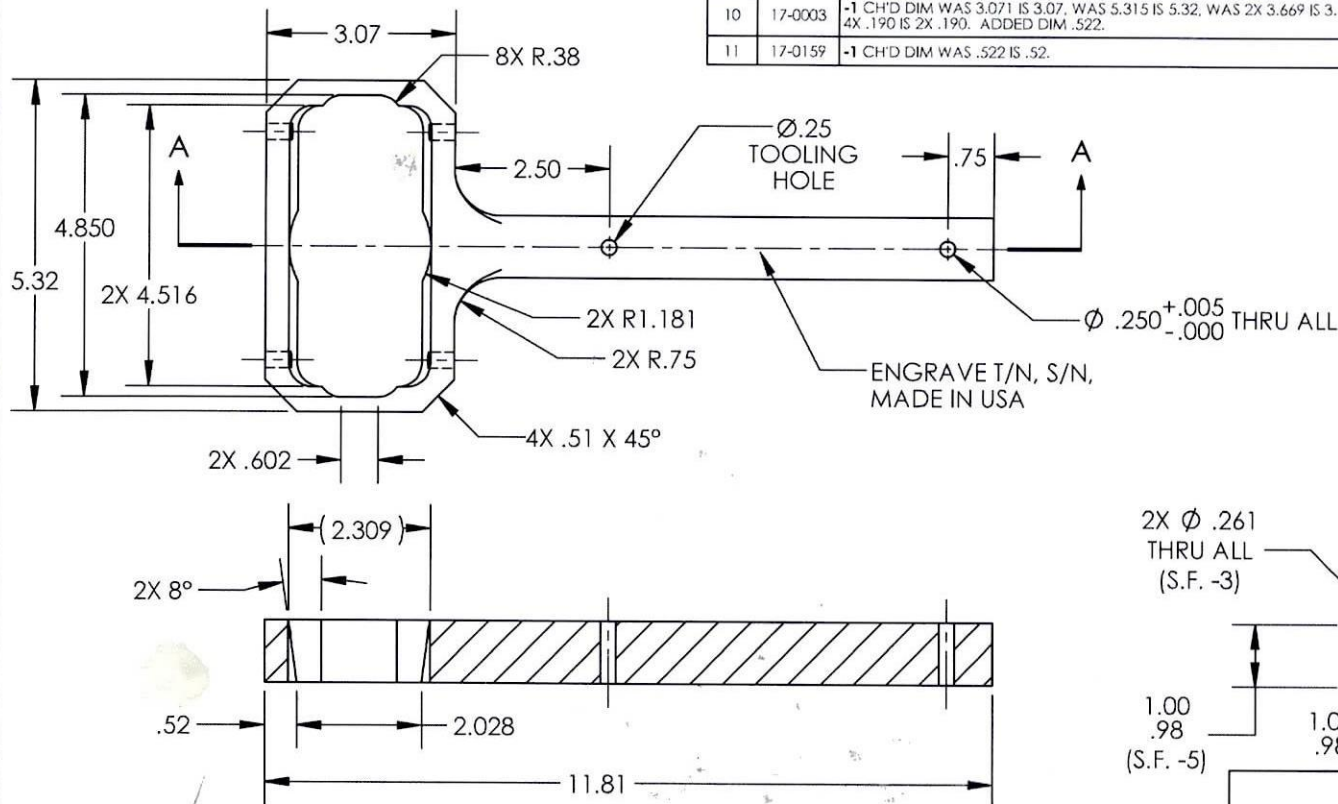
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval <i>M. Lee</i> 02/26/18							
Description Work Order Deviation R0.125 RADIUS IS R0.313 TO FIT INSIDE OF HANDLE.		Disposition - THIS DEVIATION IS ACCEPTABLE - NO CHANGE TO FIT FORM OR FUNCTION.		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ ☒ Product Improvement Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ ☒ Product Improvement Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____											

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D INSIDE ANGLED RADIUS FROM R.75 TO R.375, CH'D DIM WAS 1.122 IS 1.	12/5/2008	WP	DW
2		-1 ADDED Ø.250 HOLE.	3/18/2009	WP	DW
3		-1 ADDED 1 INCH SQUARE DIM, CH'D DIM TO 2.309.	4/29/2009	RJC	
5		-1 ADDED TOLERANCE 1.00 - .98 TO HANDLE.	10/6/2009	WP	DW
6		-1 CH'D TOOLING HOLE WAS Ø.266 IS Ø.250, ADDED ENGRAVE NOTE.	12/16/2010	RJC	RW
7		-1 CH'D DIM WAS Ø.250 IS Ø.250 +.005 -.000.	4/18/2013	CFS	JG
10	17-0003	-1 CH'D DIM WAS 3.071 IS 3.07, WAS 5.315 IS 5.32, WAS 2X 3.669 IS 3.669, WAS 2X 1.835 IS 1.835, WAS 4X .190 IS 2X .190. ADDED DIM .522.	2/28/2017	RJC	SM
11	17-0159	-1 CH'D DIM WAS .522 IS .52.	6/21/2017	RJC	JAG



SECTION A-A

(1)

HANDLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171380 MJS
1801-31

DART AEROSPACE	
TITLE T/R HUB LOCK WRENCH	
DWG NO. RBE350A93-3302-02-1	REV 11
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XX ± .005 FRACTIONS ± 1/8
FINISH BLACK ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:3	DATE 10/20/2008
SHEET 2 OF 4	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039182

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039182

PO Date: 3/2/18

Due Date: 3/16/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
MAR 14 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170833	D5501-3	Body, Lower Cutter, Short Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL- P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** As Per Dwg D5501 Rev. A7 Certification of Conformity is required	Firmed	3/26/18	6 pcs	0 pcs	6 pcs	\$16.33/pcs	\$97.98
2	170453	646.3210	Support Issue P/O to ATG : _____ 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	3/26/18	12 pcs	0 pcs	12 pcs	\$15.18/pcs	\$182.16
3	171981	646.3312	Center Plate Issue P/O to ATG : _____ Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C	Firmed	3/26/18	20 pcs	0 pcs	20 pcs	\$12.88/pcs	\$257.60
4	170464	646.3610	Filler Issue P/O to ATG : _____ 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	3/26/18	12 pcs	0 pcs	12 pcs	\$7.43/pcs	\$89.16
5	170466	646.3711	Clip Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 646.3700 Rev. A	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$6.93/pcs	\$145.53
6	170467	646.3712	Clip Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as Per Dwg 646.3712 Rev. A	Firmed	3/26/18	19 pcs	0 pcs	19 pcs	\$6.93/pcs	\$131.67
7	170468	646.3713	Gusset Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$16.58/pcs	\$348.18

Plex 3/14/18 10:36 AM dart.lavoie.chanta

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	170469	646.3714	Gusset Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$16.58/pcs	\$348.18
9	173035	647.2114	Upper U Channel Issue P/O to ATG : _____ 1- Anodize as per MPP-172 sect. 2.1 2- Pretreatment as per MPP-172 sect. 3.3 3-Prime as per MPP-172 sect. 4.3 As Per Dwg 647.2100 Rev. E	Firmed	3/26/18	10 pcs	0 pcs	10 pcs	\$12.08/pcs	\$120.80
10	172472	647.7820	Cross Bracket Aft Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O TO ATG: _____ Anodize & prime as per Dwg. 647.7800	Firmed	3/26/18	1 pcs	0 pcs	1 pcs	\$12.08/pcs	\$12.08
11	171212	647.7911	Bracket Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N as per Dwg 647.7900 Certification of Conformity is required	Firmed	3/26/18	9 pcs	0 pcs	9 pcs	\$7.73/pcs	\$69.57
12	171380	RBE350A93-3302-02-1	Handle -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$6.08/pcs	\$36.48
13	170577	RBE350A93-3500-00-1	Body -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$5.51/pcs	\$33.06
14	171139	RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3501-20 Rev. E -Certificate of Conformity is required	Firmed	3/19/18	20 pcs	0 pcs	20 pcs	\$5.51/pcs	\$110.20
15	170701	RBT112800-1	Base -Issue P/O to ATG: _____ ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As per Dwg RBT112800 Rev. 3A -Certificate of Conformity is required	Firmed	3/19/18	6 pcs	0 pcs	6 pcs	\$5.51/pcs	\$33.06



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914734

Date: 07-Mar-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
6 ea	Part: RBE350A93-3302-02-1 Handle Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (4 - 1 mils) Water Seal Job: 22642	Rev: 11 PO: PO039182 Line: 12	
6 ea	Part: RBE350A93-3500-00-1 Body Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (4 - 1 mils) Water Sealant Job: 22643	Rev: 3A PO: PO039182 Line: 13	
20 ea	Part: RBE350A93-3501-20 Extraction Tool, Hydraulic Pum Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (4 - 1 mils) Water Sealant Job: 22644	Rev: E PO: PO039182 Line: 14	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements Date: <u>07/03/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			